

Date: Thursday, 4/12/2007 8:45:10 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : SADDLE FITTING, AFT (OUTBOARD/INBOARD)
 Job Number : 31721
 Estimate Number : 10533
 P.O. Number : N/A Part Number : D2573
 This Issue : 4/12/2007 S.O. No. : N/A Drawing Number : D2573 REV E
 Prsht Rev. : NC Project Number : N/A
 First Issue : N/A Type : MACHINED PARTS Drawing Revision : E
 Previous Run : 31717 Material : N/A
 Due Date : 4/30/2007 Qty: 16 Um: Each
 Written By :
 Checked & Approved By : 07/04/12
 Comment : Est: I As Per RevE 06-01-27 JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D6101007 7075-T7351 8.25X7.75X2.5



Comment: Qty.: 1.0000 Each(s)/Unit Total : 16.0000 Each(s)

7075-T7351 8.25X7.75X2.5

Make from D6101-007 billet for D2573

Ensure that grain is along 7.75" length

Batch No: _____

B25354 (x3)
B25353 (x13) En 07/05/06

2.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

Program Batch No. B31721 Double check by: SN

1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets 2-Machine Step No 2 per

Folio FA051 and inspect per attached Dimension Sheets

3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets

4-Deburr and remove all machining marks

5-Tumble to remove sharp edges.

MS/En 07/05/15 (x16)

3.0 MILLING CONV. CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE

Machine keyway as per dwg D2573 & D2574

MS/En 07/05/15 (x16)

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

MS/En 07/05/15 (x16)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Q Date: 07/05/17
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 4/12/2007 8:45:11 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE FITTING, AFT (OUTBOARD/INBOARD)

Job Number: 31721

Part Number: D2573

Job Number:



Seq. #: Machine Or Operation: Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

SA 07.05.15

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

07-05-16 (16)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M-L 07/05/16

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

07/05/17 (16)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

07/05/17 (16)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/05/17

Job Completion



07/05/17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	31721
Description: Saddle, Aft Outboard	Part Number:	D2573
Inspection Dwg: D2573 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443	DT8682	.440	.440	.440	0.440		
B	1.745	1.755		1.749	1.748	1.749	1.749		
C	3.495	3.505		3.500	3.500	3.501	3.501		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.001	8.002	8.001	8.001		
F	0.490	0.510		.501	.500	.500	0.500		
G	0.257	0.262	DT8683	.259	.258	.258	0.258		
H	0.375	0.380	DT8684	.376	.376	.376	0.376		
I	0.490	0.510		.500	.500	.501	0.501		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.560	.561	.560	0.560		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.365	1.375		1.368	1.368	1.368	1.368		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	4.119	4.129		4.124	4.123	4.124	4.124		
P	0.115	0.135		.132	.132	.132	0.132		
Q	0.115	0.135		.128	.128	.128	0.128		
R	0.240	0.260		.250	.252	.252	.252		
S	0.115	0.135		.128	.128	.128	.128		
T	0.178	0.198		.188	.188	.188	.188		
U	3.210	3.250		3.232	3.230	3.230	3.230		
V	0.230	0.250		.242	.240	.240	0.240		
W	0.115	0.135		.128	.125	.125	0.125		
X	0.308	0.313		.310	.310	.310	0.310		
Y	0.760	0.765		.762	.762	.762	0.762		
Z	0.352	0.372		.362	.362	.362	0.362		
AA	0.470	0.530		.500	.500	.500	0.500		
AB	0.615	0.635		.625	.626	.626	0.626		
AC	0.053	0.073		.063	.063	.063	0.063		
AD	0.240	0.260		.251	.250	.250	0.250		
AE	1.500	1.520		1.513	1.513	1.513	1.513		
AF	0.115	0.135		.125	.125	.125	0.125		
AG	0.240	0.280		.250	.250	.250	0.250		
AH	0.240	0.260		.251	.250	.251	0.251		
AI	2.000	2.020		2.003	2.000	2.000	2.000		
AJ	0.023	0.043		.032	.032	.032	0.032		
Accept/Reject									

Measured by:	MS
Date:	07/05/09

Audited by:	SD
Date:	07.05.09

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

DART AEROSPACE LTD	Work Order:	31721
Description: Saddle, Aft Outboard	Part Number:	D2573
Inspection Dwg: D2573 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443	DT8682	0.440	0.440	0.440	0.440		
B	1.745	1.755		1.748	1.747	1.749	1.749		
C	3.495	3.505		3.499	3.500	3.500	3.498		
D	1.745	1.755		1.748	1.747	1.749	1.749		
E	7.990	8.010		8.003	8.003	8.004	8.003		
F	0.490	0.510		0.497	0.501	0.498	0.498		
G	0.257	0.262	DT8683	0.260	0.260	0.260	0.260		
H	0.375	0.380	DT8684	0.377	0.377	0.377	0.377		
I	0.490	0.510		0.501	0.502	0.498	0.500		
J	1.174	1.184		1.176	1.176	1.179	1.175		
K	0.558	0.578		0.566	0.565	0.565	0.565		
L	1.174	1.184		1.176	1.176	1.179	1.175		
M	1.365	1.375		1.366	1.368	1.369	1.366		
N	2.495	2.505		2.495	2.497	2.498	2.497		
O	4.119	4.129		4.122	4.121	4.121	4.121		
P	0.115	0.135		0.127	0.127	0.127	0.127		
Q	0.115	0.135		0.135	0.135	0.135	0.135		
R	0.240	0.260		0.252	0.252	0.252	0.252		
S	0.115	0.135		0.128	0.128	0.130	0.128		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	3.210	3.250		3.230	3.230	3.230	3.230		
V	0.230	0.250		0.237	0.239	0.237	0.240		
W	0.115	0.135		0.136	0.129	0.130	0.129		
X	0.308	0.313		0.310	0.309	0.310	0.310		
Y	0.760	0.765		0.765	0.765	0.765	0.765		
Z	0.352	0.372		0.362	0.360	0.368	0.365		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.630	0.630	0.629	0.628		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.247	0.245	0.247	0.247		
AE	1.500	1.520		1.512	1.512	1.512	1.512		
AF	0.115	0.135		0.135	0.135	0.135	0.135		
AG	0.240	0.280		0.260	0.260	0.260	0.260		
AH	0.240	0.260		0.248	0.248	0.250	0.252		
AI	2.000	2.020		2.002	2.002	2.002	2.002		
AJ	0.023	0.043		0.033	0.033	0.033	0.033		
Accept/Reject									

Measured by:	EN
Date:	07/05/14

Audited by:	SA
Date:	07.05.11

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

DART AEROSPACE LTD	Work Order:	31721
Description: Saddle, Aft Outboard	Part Number:	D2573
Inspection Dwg: D2573 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443	DT8682	0.440	0.440	0.440	0.440		
B	1.745	1.755		1.746	1.750	1.748	1.750		
C	3.495	3.505		3.500	3.499	3.500	3.500		
D	1.745	1.755		1.746	1.750	1.749	1.750		
E	7.990	8.010		8.004	8.004	8.006	8.003		
F	0.490	0.510		0.499	0.502	0.501	.500		
G	0.257	0.262	DT8683	0.260	0.260	0.260	0.260		
H	0.375	0.380	DT8684	0.377	0.377	0.377	0.377		
I	0.490	0.510		0.502	0.500	0.502	.501		
J	1.174	1.184		1.177	1.176	1.175	1.176		
K	0.558	0.578		0.567	0.566	0.565	.565		
L	1.174	1.184		1.177	1.176	1.175	1.175		
M	1.365	1.375		1.367	1.365	1.369	1.370		
N	2.495	2.505		2.496	2.497	2.495	2.498		
O	4.119	4.129		4.123	4.122	4.122	4.122		
P	0.115	0.135		0.127	0.127	0.127	.128		
Q	0.115	0.135		0.135	0.135	0.135	0.135		
R	0.240	0.260		0.253	0.252	0.252	.252		
S	0.115	0.135		0.126	0.129	0.130	.130		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	3.210	3.250		3.230	3.230	3.230	3.230		
V	0.230	0.250		0.243	0.240	0.240	.240		
W	0.115	0.135		0.131	0.132	0.131	.132		
X	0.308	0.313		0.311	0.311	0.310	.312		
Y	0.760	0.765		0.765	0.765	0.765	0.765		
Z	0.352	0.372		0.365	0.365	0.365	.365		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.628	0.627	0.625	.628		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.249	0.248	0.253	.253		
AE	1.500	1.520		1.511	1.511	1.512	1.511		
AF	0.115	0.135		0.135	0.135	0.135	0.135		
AG	0.240	0.280		0.260	0.260	0.260	0.260		
AH	0.240	0.260		0.253	0.250	0.250	.250		
AI	2.000	2.020		2.001	2.002	2.002	2.001		
AJ	0.023	0.043		0.033	0.033	0.033	0.033		
Accept/Reject									

Measured by:	EM / MB
Date:	01/05/14

Audited by:	SA
Date:	07.05.15

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

DART AEROSPACE LTD	Work Order:	31721
Description: Saddle, Aft Outboard	Part Number:	D2573
Inspection Dwg: D2573 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

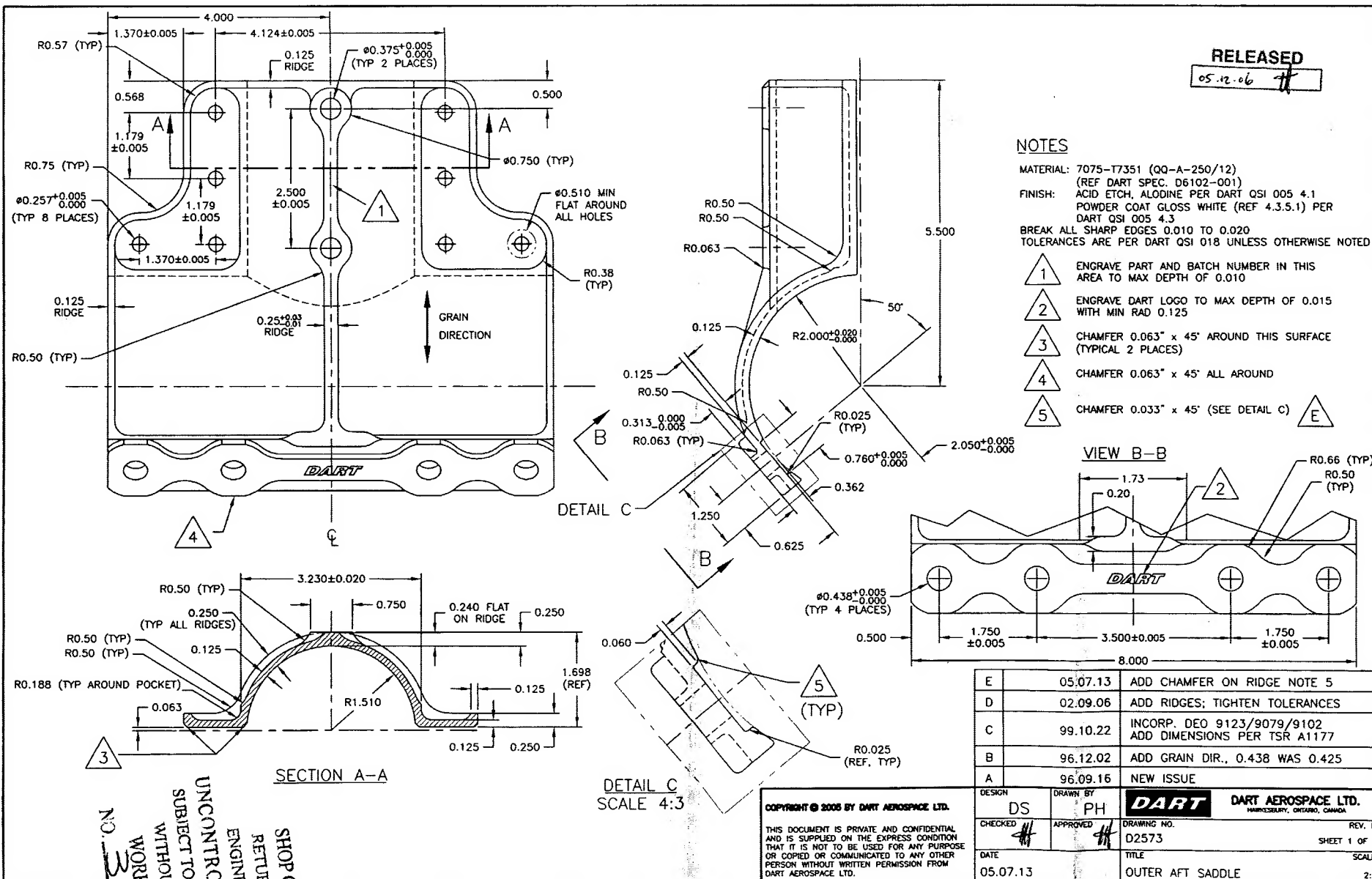
				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443	DT8682	.440	.440	0.440	0.440		
B	1.745	1.755		1.749	1.750	1.748	1.748		
C	3.495	3.505		3.500	3.500	3.501	3.500		
D	1.745	1.755		1.750	1.750	1.748	1.740		
E	7.990	8.010		8.001	8.002	8.004	8.003		
F	0.490	0.510		.501	.501	0.499	0.495		
G	0.257	0.262	DT8683	.258	.258	0.260	0.260		
H	0.375	0.380	DT8684	.378	.378	0.377	0.377		
I	0.490	0.510		.500	.500	0.503	0.502		
J	1.174	1.184		1.179	1.178	1.175	1.175		
K	0.558	0.578		.568	.568	0.566	0.568		
L	1.174	1.184		1.179	1.178	1.175	1.175		
M	1.365	1.375		1.370	1.370	1.369	1.368		
N	2.495	2.505		2.500	2.499	2.498	2.498		
O	4.119	4.129		4.125	4.125	4.119	4.122		
P	0.115	0.135		.132	.132	0.126	0.126		
Q	0.115	0.135		.130	.130	0.135	0.135		
R	0.240	0.260		.250	.250	0.257	0.257		
S	0.115	0.135		.126	.126	0.126	0.127		
T	0.178	0.198		.188	.188	.188	.188		
U	3.210	3.250		3.230	3.230	3.230	3.230		
V	0.230	0.250		.240	.240	0.236	0.236		
W	0.115	0.135		.125	.125	0.129	0.132		
X	0.308	0.313		.312	.312	0.310	0.310		
Y	0.760	0.765		.762	.762	0.765	0.765		
Z	0.352	0.372		.365	.365	0.362	0.362		
AA	0.470	0.530		.500	.500	0.500	0.500		
AB	0.615	0.635		.625	.625	0.628	0.629		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.250	.250	0.249	0.245		
AE	1.500	1.520		1.512	1.513	1.512	1.512		
AF	0.115	0.135		.125	.125	0.135	0.135		
AG	0.240	0.280		.260	.262	0.260	0.260		
AH	0.240	0.260		.252	.250	0.248	0.247		
AI	2.000	2.020		2.002	2.003	2.002	2.002		
AJ	0.023	0.043		.032	.032	.032	.032		
Accept/Reject									

Measured by: MS	Audited by: SD
Date: 07/05/14	Date: 07.05.15

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

RELEASED

05.12.06



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SUBJECT TO AMENDMENT
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WORK ORDER
NO. 31721